

Work Order ID 65969

January 31, 2011 8:47:10 AM



Page 1

Item ID: D3067-1

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 1/31/11 Start Qty: 120.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

CL

Date: 1/31/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3067	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3067

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

5052.063

1311-31



110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1311-31

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5052.063

count
100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3067	0.00 0.00		SR 11/02/01		(150)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sub 02/01		COUNT (450)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo *** STOCK IN STEP CELL ***	0.00 0.00		11.02.12		150			

W/O:		WORK ORDER CHANGES					
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January 31, 2011 8:47:10 AM



Page 3

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Start Date: 1/31/11

Start Qty: 120.00



Cust Item ID:

Required Date: 2/04/11

Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/02/14 JF

MR

11-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

January 31, 2011 8:47:10 AM

Page 1

Work Order ID: 65969



Parent Item: D3067-1



Parent Item Name: End Plate



Start Date: 1/31/11

Required Date: 2/04/11

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: ☐ 03.01.21 Remove step 6 (Deburr) KJ ☐
IPP Rev:B Now on Water jet 06-06-16 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		100	sf	158.0000	0.0625	7.894737		9.4	
												B11-1-31	

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT

158

114322

158

114322

(150)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

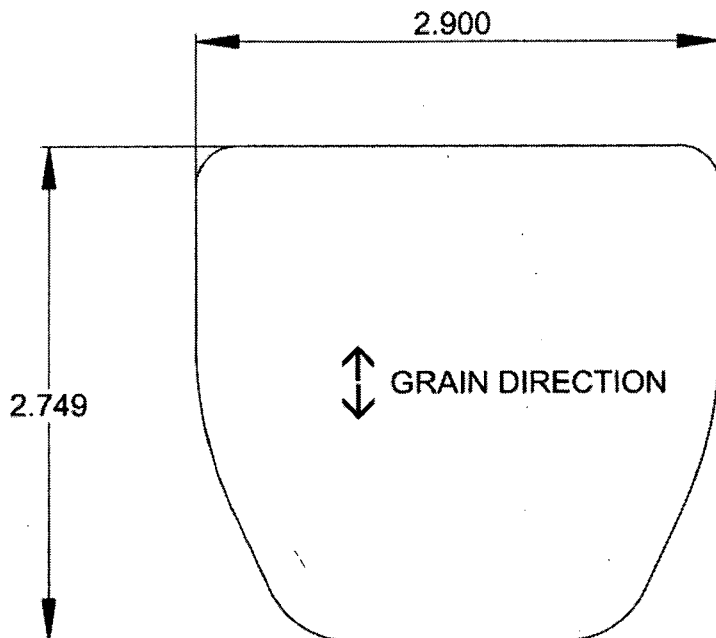
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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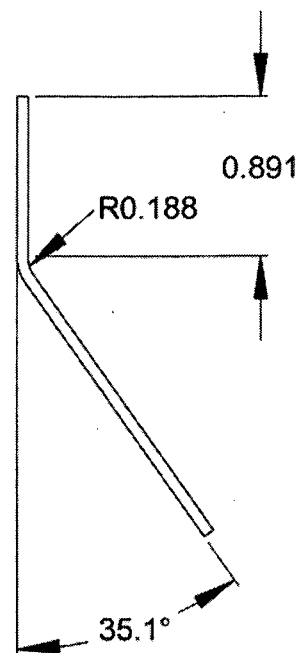


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE END PLATE		SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

CL11/01/31

W10: 65969

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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